

Date: Tuesday, 7/1/2008 2:34:59 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE KIT
Job Number : 40194	
Estimate Number : 10532	
P.O. Number :	Part Number : K10003
This Issue : 7/1/2008 S.O. No. :	Drawing Number : K10003
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 39991	Material :
Written By :	Due Date : 7/30/2008 Qty: 8 Um: Each
Checked & Approved By : <u>108.07.01</u>	
Comment : Est : I 09.01.16 Reformat: Incorporated D205-641-011 KJ/RF Est : J 06-07-25 As per DSI 9344 JLM Est : K 06.11.17 Per K10003 Rev C KJ Est : L 07.01.12 Document Record for copying bluefile rmv KJ	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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S 08/08/12



Comment: DOCUMENT CONTROL

Create White labels only per PPP K10003

CHG 005

006 94N 08-507

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	D2570	Bushing
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Comment: Qty.: 24.0000 Each(s)/Unit Total : 192.0000 Each(s)

Bushing

Pick:

Qty	Part Number	Description	Batch
24	D2570	Bushing	<u>39367 175X 40197 17X</u>

4.0	D2571	Saddle, Fwd Out 205
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Saddle, Fwd, Out

Pick:

Qty	Part Number	Description	Batch
1	D2571	Saddle	<u>3980670 38122 10</u>

8/7/30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 7/1/2008 2:34:59 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT

Job Number: 40194

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2572

Saddle, Fwd In 205



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Saddle, Fwd, In

Pick:

Qty	Part Number	Description	Batch
1	D2572	Saddle	39807 70 40085 10

6.0

D2573

Saddle, Aft Out 205



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Saddle, Aft, Out

Pick:

Qty	Part Number	Description	Batch
1	D2573	Saddle	39475

7.0

D2574

Saddle, Aft In 205



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Saddle, Aft, In

Pick:

Qty	Part Number	Description	Batch
1	D2574	Saddle	39476

8.0

D27361

Lug Assembly, 205 GHW



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Lug Assembly

Pick:

Qty	Part Number	Description	Batch
1	D2736-1	Bracket	39864 70 39841 10

9.0

D27363

Lug Assembly, 205 GHW



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Lug Assembly

Pick:

Qty	Part Number	Description	Batch
1	D2736-3	Bracket	39842

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 08/08/2008 8:57:07 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE KIT
 Job Number : 40194
 Estimate Number : 10532
 P.O. Number :
 This Issue : 08/08/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 01/07/2008 Type : MACHINED PARTS
 Previous Run : 39991
 Part Number : K10003
 Drawing Number : K10003
 Project Number : N/A
 Drawing Revision : C
 Material :
 Due Date : 30/07/2008 Qty: 8 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est : I 03.01.16 Reformat: Incorporated D205-641-011
 KJ/RF
 Est : J 06-07-25 As per DSI 9344 JLM
 Est : K 06.11.17 Per K10003 Rev C KJ
 Est : L 07.01.12 Document Record for copying bluefile rmv KJ

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

13.0

D3407045

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Tow Ring

Pick:

Qty	Part Number	Description	Batch
1	D2968-041	Tow Ring	B40404

13.1

D34561

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

13.2

MS210434

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

13.3

D34175

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Washer

Date: Friday, 08/08/2008 8:57:07 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT

Job Number: 40194

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.4

D38121

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 16.0000 Each(s)

Washer

24/10000

See Seq. 14 on original

14.0

D35331

Set Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 16.0000 Each(s)

Set Screw

Batch:

See Seq. 14 on original

Job Completion



u

Date: Tuesday, 7/1/2008 2:34:59 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT

Job Number: 40194

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

D2747

Set Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 32.0000 Each(s)

Set Screw

Pick:

Qty	Part Number	Description	Batch
4	D2747	Socket Head Set Screw	39229

11.0

D2876

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Saddle Spacer

Pick:

Qty	Part Number	Description	Batch
2	D2876	Spacer	36275

12.0

D2877

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Saddle Spacer

Pick:

Qty	Part Number	Description	Batch
2	D2877	Spacer	36276

13.0

D2968041

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Tow Ring

Pick:

Qty	Part Number	Description	Batch
1	D2968-041	Tow Ring	

14.0

D35331

Set Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Set Screw

Batch:

28093

15.0

AN46A

Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total : 128.0000 Each(s)

Bolt

Pick:

M107534

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT

Job Number: 40194

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description :

Qty	Part Number	Description	Batch
16	AN4-6A	Bolt	

16.0

AN446A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 32.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
4	AN4-6A	Bolt	

M107137 3x M10 8246 29x

17.0

AN451A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
8	AN4-51A	Bolt	

M108077

18.0

AN612A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
8	AN6-12A	Bolt	

M107823

19.0

AN960JD416

Washer



Comment: Qty.: 32.0000 Each(s)/Unit Total : 256.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
32	AN960JD416	Washer	

M107935

20.0

AN960JD616

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
8	AN960JD616	Washer	

M107959

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 40194

Part Number: K10003

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

AN9704

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Pick:

Qty

Part Number

Description

Batch

1

AN970-4

Washer

M108377

22.0

MS21042L4

Nut



Comment: Qty.: 29.0000 Each(s)/Unit Total : 232.0000 Each(s)

Nut

Pick:

Qty

Part Number

Description

Batch

29

MS21042L4

Nut (or MS21042-4)

M107478

PC 8/7/29

23.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT KITS 100% FOR COMPLETENESS

S 08/08/12

24.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Rev H

SS 08/08/12

25.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

8
A 08/08/12

Job Completion



mf 08-08-12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED #	DRAWING NO. K10003	REV. C SHEET 1 OF 1
DATE 06.11.07		TITLE SADDLE KIT	SCALE NTS
A	00.06.01	NEW ISSUE	
B	00.11.22	ADD D2707-041 OPTION	
C	06.11.07	ADD D3533-1	

RELEASED

06.11.13 #

THIS KIT CONTAINS PARTS AND PAPERWORK APPLICABLE TO THE FOLLOWING SKIDTUBE AND SADDLE INSTALLATIONS:

AIRCRAFT	INSTALLATION
BELL 205/210/212/412	D205-634-011 D205-634-015
BELL 204	D204-635-011

THE FOLLOWING PARTS SHOULD BE USED PER THE RELEVANT DRAWINGS AND THE FOLLOWING TABLE (REF):

PART NUMBER	K10003	D205-634-011 D205-634-015	D204-635-011
D205-641-011	1	1	1
D2570	16	16	16
D2571	1	1	1
D2572	1	1	1
D2573	1	1	1
D2574	1	1	1
D2747	4	4	4
D2876	2	2	2
D2877	2	2	2
D2707-041 (or D2968-041)	1	1	1
D3533-1	2	2	2
AN4-51A	8	8	8
AN4-6A	16	16	16
AN6-12A	8	8	8
AN960JD416	32	32	32
AN960JD616	8	8	8
*AN960JD1016	1	1	1
AN970-4	1	1	1
MS21042-4 (OR L4)	25	25	25

* REQUIRED WITH D2707-041 ONLY

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WORK ORDER
NO. 40194